

Work Order ID 70458-1

Wednesday, June 08, 2011 7:42:26 PM

Page 1

Item ID: D2573

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/23/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Program Batch No. 70458 Double check by: 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/22 (2)

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

0.00

Machine keyway as per dwg D2573 & D2574

SL 11/06/22

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL 11/06/22

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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• NOTE: Date & initial all entries

Work Order ID 70458

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Accept

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Reference:

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Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

11-6-22

2

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

2 Bl 11-6-22

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

11:00

2x Ø m-l 11/06/22

M 116964

10-30

W/O:		WORK ORDER CHANGES					
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Accept

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Required Date: 6/23/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 434

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

2 0 BL 11-6-22

11/6/22 SF

11/6/22 JF

mf
11-06-22

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Picklist Print

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Page 1

Work Order ID: 70458

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205



Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007

Manufactured No

100

Each

39.0000

1

12



Saddle Billet



21 Nov/22

Location

Loc Qty

Loc Code

MAT042

9

66967

9

MAT045

30

65383

13

65954

17

70678

12

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DART AEROSPACE LTD		Work Order: 70758
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001			
F	0.490	0.510		.500	.499				
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500			
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.568			
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125			
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.251			
S	0.115	0.135		.129	.129	.127			
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.239	.240	.239			
W	0.115	0.135		.130	.130	.128			
X	0.308	0.313		.307	.310				
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.365				
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.625				
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.250			
AE	1.500	1.520		1.513	1.512	1.511			
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.251	.250	.250			
AI	2.000	2.020		2.003	2.002	2.001			
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: SL
Date: 11/06/21

Audited by: RQ
Date: 11.6.22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format: Added Rev. D	KJ	
C	02.10.11	Re-format: Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/MLM	

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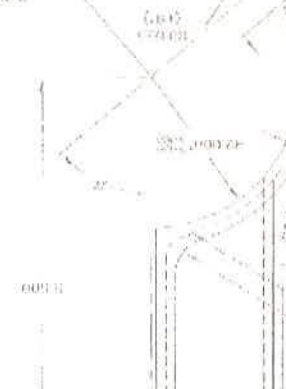
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[illegible]

(13)

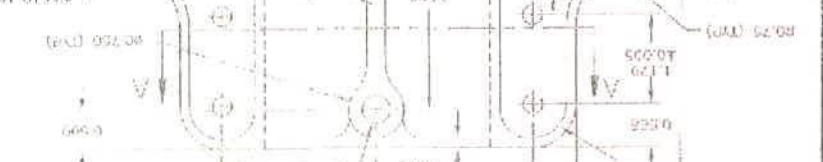
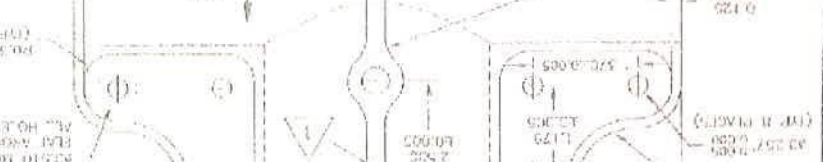
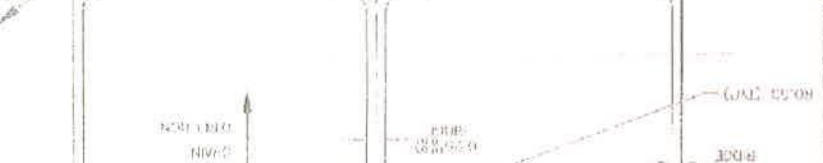
C



SECTION

79-10-10

10



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